

Date: Tuesday, 29/07/2008 9:05:12 AM
User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	AFT BLADE FOLD ASSY WELDMENT
Job Number	: 40772		
Estimate Number	: 13503		
P.O. Number	:	Part Number	: PB674300109
This Issue	: 29/07/2008 S.O. No. :	Drawing Number	: B6743001 P.6
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 05/08/2008 Qty:
Checked & Approved By	: <u>DMT</u> 08-07-29		
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description	
1.0	PB6743001211	Square Tubing	
			<i>PL 08-07-30</i>
Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)			
Square Tubing batch: <u>340596</u>			
2.0	PB6743001209	Square Tubing	
			<i>PL 08-07-31</i>
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
Square Tubing batch: <u>340595</u>			
3.0	PB6743001201	Square Tubing	
			<i>PL 08-07-31</i>
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)			
Square Tubing batch: <u>340592</u>			
4.0	PB6743001203	Square Tube	
			<i>PL 08-07-31</i>
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
Square Tube batch: <u>340594</u>			
5.0	PB6743001239	Square Tube	
			<i>PL 08-07-31</i>
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
Square Tube batch: <u>340555</u>			

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Part Number: PB674300109

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PB6743001235

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Outer Tube

batch:- 340771

JL 08.07.31

3

7.0 PB6743001229

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Outer Tube

batch:- 340779

JL 08.07.31

3

8.0 PB6743001213

Flanged Hook



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Flanged Hook

batch:- 340040

JL 08.07.31

3

9.0 PB6743001311

Restraint



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Restraint

batch:- M17695

JL 08.07.31

3

10.0 PB6743001277

Contoured Hinge Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Contoured Hinge Arm

batch:- 323828=1

340059=3

JL 08.07.31

3

11.0 PB6743001243

Handle Arm Extension



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Handle Arm Extension

batch:- 340044

JL 08.07.31

3

12.0 D34409

Tube Detent Clip Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube Detent Clip Base

batch:- 323736

JL 08.07.31

3

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Job Number: 40772 Part Number: PB674300109

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D344013	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

batch: 324013B



✓ 08.08.07 3

14.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

ensure no burn thru after welding in tube -235 and -229

08.08.06 ✓ 08.08.07



3

15.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION



A.

Pd 08.08.08 (3)

16.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP



S 08/08/08 X3

17.0	POWDER COATING	POWDER COATING
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M102316



3X

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

8:15

START TIME:

320 °F

OVEN TEMPERATURE:

8:45

FINISH TIME:

m-f

08/08/11

18.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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HJ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-11

X3

19.0	PACKAGING 1	PACKAGING RESOURCE #1
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39952



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

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Seq. #: Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/bb
d/j

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

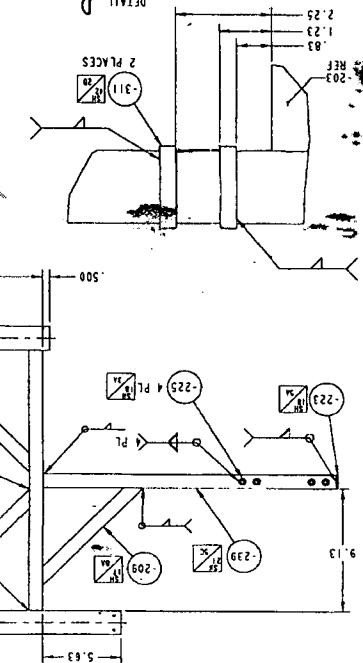


u 08.08.26

ORIGINAL

① -09 AFT BLADE EOLD ASSEMBLY WELDMENT

DETAIL 1
SCALE 0.750



1

SEE DETAIL 6

SCALE 0.500

The diagram illustrates a cylindrical component with several internal features and associated labels:

- OUTLET TUBE**: Located at the top right, pointing to a tube exiting the cylinder.
- FLANGE OF LOWER HORN**: Located at the bottom right, pointing to a flange on the lower part of the cylinder.
- CENTER LINE OF CYLINDER**: A dashed horizontal line through the center of the cylinder.
- ALIGN WITH CENTERLINE**: A label near the bottom left.
- ALIGN WITH CYLINDER FLANGE**: A label near the bottom center.
- ALIGN WITH CYLINDER FLANGE**: A label near the bottom right.
- WITH THE HORN TO ONE**: A label near the middle left.
- ALIGN WITH CENTERLINE OF CYLINDER**: A label near the middle center.
- ALIGN WITH CENTERLINE OF CYLINDER**: A label near the middle right.
- MOTION SURFACE OF END CAP**: A label near the top left.
- ALIGN WITH CENTERLINE**: A label near the top center.
- OF OUTLET TUBE AND TO**: A label near the top right.
- MOTION SURFACE OF END CAP**: A label near the top left.

A schematic diagram of a probe assembly. It features a central cylindrical body with a flared base. A probe extends from the top, ending in a circular cap. Two wires, labeled J38 and EE2, are connected to the probe. A third wire, labeled E13, is connected to the central body. The entire assembly is mounted on a base plate.

ALL AROUND TAPE
1.00 NO PAPER

30-35

2271 EX 14

— 1 —